

Date: Monday, 4/30/2007 7:24:19 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	PLUG
Job Number	32118		
Estimate Number	10512		
P.O. Number	N/A	Part Number	D26511
This Issue	4/30/2007	Drawing Number	D2651 REV. B
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	B
Previous Run	31788	Material	N/A
Written By		Due Date	5/4/2007
Checked & Approved By	<u>John A. Johnston</u>	Qty:	44
Comment	Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
		Comment: Qty.: 0.0421 f(s)/Unit Total : 1.8526 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <u>M104187</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651  2- Deburr	  <u>MS 07/06/25</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	  <u>MS 07/06/25</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	  <u>MS 07/06/25</u>
4.0	QC8	SECOND CHECK	  <u>MS 07/06/25</u>
		Comment: SECOND CHECK	  <u>MS 07/06/25</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	  <u>MS 07/07/04</u>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651	  <u>MS 07/07/04</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32118		Part Number: D26511
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 (45) <i>BR/m/107-07-04</i>
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	SPRAY PAINTING 	SPRAY PAINTING <i>P10: 4105 C20/107/05 (45)</i> 
Comment: SPRAY PAINTING PRIME SPRAY PAINT DELFLEET BLUE		
8.0	QC14 	INSPECT SPRAY PAINT <i>J07-07-11</i> 
Comment: INSPECT POWDER COAT		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 (45X) <i>1/1/11 50</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE (45) <i>1/1/11 Dart 10</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion	 <i>✓ 4/30/11</i>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

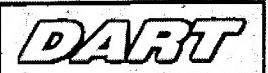
DART AEROSPACE LTD	Work Order:	32118
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	M8	Audited by:	DKL	Prototype Approval:	N/A
Date:	07/06/25	Date:	07/06/25	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	TT



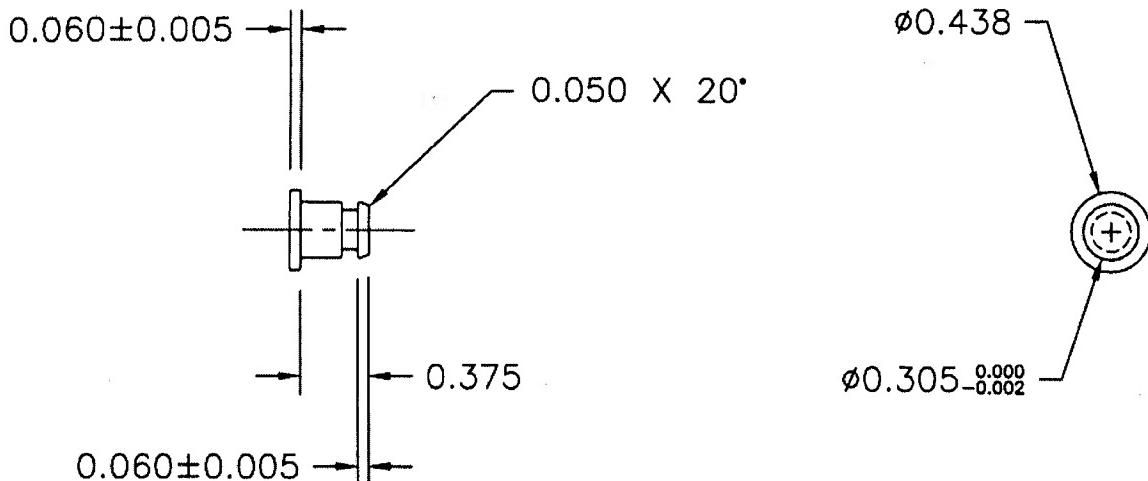
COPY ISSUED  
03/12/19

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

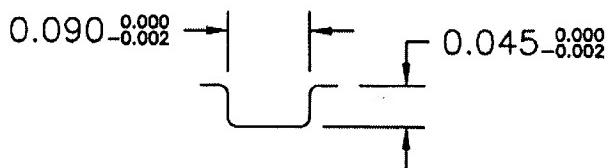
RELEASED

03.12.19 ✓

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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WORK ORDER  
NO. 35118

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